Eate:

Wednesday, 26/11/2008 12:46:04 PM

User:

Julie Dawson

## **Process Sheet**

Customer

: CU-DAR001 Dart Helicopters Services

S.O. No. :

Job Number

: 43751

**Estimate Number** 

: 10993

P.O. Number This Issue

: 26/11/2008

Prsht Rev. First Issue : NC

: //

Type

: MACHINED PARTS

Previous Run

: 41666

Written By

Checked & Approved By

Comment

est

07.07.06 rev E dwg

Now turned on Cobra NG

**Drawing Name** 

: CROSSBOLT SPACER

Part Number

: D2579

**Drawing Number** 

: D2579 REV E

**Project Number Drawing Revision** 

: N/A : E

Material

**Due Date** 

: 20/12/2008

Qty:

500 Um:

Each

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

**Description:** 

1.0

M6061T6T0500W058

6061-T6 RD Tube .500 x.058W

Comment: Qty.:

0.3762 f(s)/Unit Total: 188.1075 f(s)

6061-T6 Tube .500 x.058W

Material: 6061-T6 (WW-T-700/6) or 5052-H32 (WW-T-700/4)

0.500 Dia x 0.058 Wall

Batch 109115

Stock

2.0

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

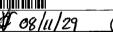
Machine as per Folio FA245

QC2



Comment: INSPECT

PARTS AS THEY COME OFF MACHINE



4.0

3.0

QC8

SECOND CHECK



Comment: SECOND CHECK



5.0

PACKAGING 1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock Location!

Page 1

# **Dart Aerospace Ltd**

W/O:	•		WO	RK ORDER CHANGE	=\$				
DATE	STEP	PRO	OCEDURE CHAN		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cateç	gory:	NCR: Yes	No DQ	A:	Date: _	
	Re	solution:	Disposition	);	QA: N/C	Closed:		Date:	
NCR:			WORK ORDE	ER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Action Description	on B Sign		cation	Approval Chief Eng	Approval QC Inspector
		Godian	Chief Eng	Chief Eng	Dat	e			
,,,,									
1									

NOTE: Date & initial all entries

Date: User:

Wednesday, 26/11/2008 12:46:04 PM

Julie Dawson

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CROSSBOLT SPACER

Job Number: 43751

Part Number: D2579

Job Number:



Seq. #:

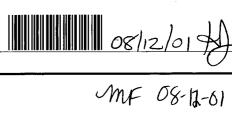
**Machine Or Operation:** 

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aer	ospace	<b>Ltd</b>							
W/O:			W	ORK ORDER CHANGE	S				
DATE	STEP	· PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	:							7-1-18-	
Part No:	!	PAR #:	_ Fault Cat	egory:	NCR: Yes	No DQ	<b>A</b> :	Date: _	
Resolution:			Dispositi	on:	QA: N/C Closed: Date:				
NCR:		W	ORK ORI	DER NON-CONFORMAT	NCE (NC	R)			
D.4.T.E.		Description of NC	Corrective Action Section B		on B Verification		cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	ion C	Chief Eng	QC Inspector
								:	

NCR:		· ·	WORK ORD	ER NON-CONFORMANC	ON-CONFORMANCE (NCR)					
		Description of NC	Corrective Action Section B			Verification	Ammuoval	Ammerical		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector		
			·							
			·							

NOTE: Date & initial all entries

DART AEROSPACE LTD

Work Order: 4375 \

Description: Cross Bolt Spacer

Part Number: D2579

Inspection Dwg: D2579

Rev: E

Page 1 of 1

#### FIRST ARTICLE INSPECTION CHECKLIST

	X	First Article		Prototype
--	---	---------------	--	-----------

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.070	+/-0.030	4.070				
0.058	+/-0.010	0.058	/			
						···
	-					

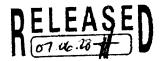
Measured by:	Audited by: J.L	Prototype Approval:	N/A
Date: 08/11/28	Date: 6\\\/\/	Q9 Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	03.11.27	New Issue	KJ/RF	
В	07.09.06	Dwg Rev updated	KJ/JLM X	E
			, ()	

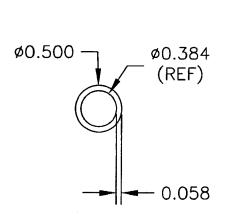
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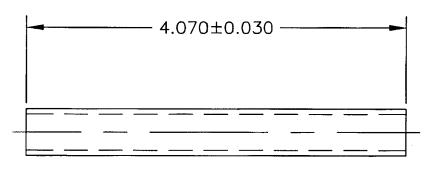


	DESIGN DRAWN BY			DART AEROSPACE HAWKESBURY, ONTARIO, CANAD	
į	CHEC	KED Jul.	APPROVED	DRAWING NO.	REV. E
		一树	#	D2579	SHEET 1 OF 1
	DATE			TITLE	SCALE
	07.0	04.17		CROSS BOLT SPACER	1:1
	Α		96.09.16	NEW ISSUE.	
	В		96.12.05	0.065 WALL WAS 0.035 WALL	



07.0	04.17	CROSS BOLT SPACER 1:1
Α	96.09.16	NEW ISSUE.
В	96.12.05	0.065 WALL WAS 0.035 WALL
С	97.02.21	0.058 WALL WAS 0.065 WALL
D	99.05.19	4.070 LENGTH WAS 4.100 (TSR A1095)
E	07.04.17	UPDATE NOTES





### D2579 CROSS BOLT SPACER

#### D2579 CROSS BOLT SPACER

1) MATERIAL:

6061-T6 TUBING PER WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8

(REF DART SPEC M6061T6T0500W058)

SHOP COPY

2) FINISH:

NONE

RETURN TO

3) ALL DIMENSIONS ARE IN INCHES

ENGINEERING

) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITHOUT NOTICE
WORK OR DER

NO.43751

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